



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5552-3
Job Sheet 170808



(D)

Part No: D5552-3

Job Qty: 12 ea

Part Name: Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/19/18

Job Tracking No:

Due Date: 2/26/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG D5552 REV.A SHEET 2 IPP REV:A 17.09.01 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	2/26/18	2/26/18	0.00	0.00	Start Up Waterjet		SC 18/01/26
100	Waterjet	12 pcs	2/26/18	2/26/18	0.00	0.00	Waterjet1		SC 18/01/26
110	QC	12 pcs	2/26/18	2/26/18	0.00	0.00	QC2 Waterjet-4		SC 18/01/26
120	CNC Vertical Machining	12 pcs	2/26/18	2/26/18	0.00	0.00	HAAS1-1		SC 18/02/18
130	QC	12 pcs	2/26/18	2/26/18	0.00	0.00	QC2 Machining-4		SC 18/02/18
140	QC	12 pcs	2/26/18	2/26/18	0.00	0.00	QC8 Machining-4		SC 18-02-21
150	HandFinish	12 pcs	2/26/18	2/26/18	0.00	0.00	HandFinish1		SC 18-02-21
160	QC	12 pcs	2/26/18	2/26/18	0.00	0.00	QC7-5		SC 18-02-21
170	Powdercoat	12 pcs	2/26/18	2/26/18	0.00	0.00	Powdercoat1		SC 18-02-21
180	QC	12 pcs	2/26/18	2/26/18	0.00	0.00	QC3		SC 18-02-21
190	Packaging	12 pcs	2/26/18	2/26/18	0.00	0.00	Packaging3-2	5175	SC 18-02-21
200	QC21-SA	12 Ea	2/26/18	2/26/18	0.00	0.00	QC21		SC 18-02-21

Part Op 100 - 1-Cut contour and pocket as per Dwg Dwg Rev: A Prog Rev: A 2-Deburr if necessary

Descriptions: 120 - Face and drills holes as per dwg Dwg Rev: A

170 - ***Mask holes or blow out access powdercoat in holes*** START TIME: 4:45 OVEN TEMPERATURE: 21

FINISH TIME: 5:15 11/38467

FEB 29 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.750X03.000	6061-T6 Bar .750 X 3.00	2.5200 ft (.21 ea)	90-Start up Operation	

Part Specifications

Specifications could not be found.

Plex 1/19/18 1:21 PM dart.poulin.mario

QA Closed: _____ Date: _____		Work Order update only																																											
Work Order: _____ Part No. _____ NCR # _____ Date : _____		DISPOSITION Rework ☐ Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com																																											
 Spacer PART NO: D5552-3 Original Serial #: S036050 Revision: Operation: Change No: Start up Operation 01/26/18 Job No: 170808		AGAINST DEPARTMENT/PROCESS <table border="1" style="width:100%; border-collapse: collapse;"> <tr> <td>Loss tube</td><td>☐</td> <td>Water Jet</td><td>☐</td> <td>Engineering</td><td>☐</td> </tr> <tr> <td>Small Fab</td><td>☐</td> <td>Prod. Eng. Coord.</td><td>☐</td> <td>Quality</td><td>☐</td> </tr> <tr> <td>Finishing</td><td>☐</td> <td>Rec/Store/Packaging</td><td>☐</td> <td>Other</td><td>☐</td> </tr> <tr> <td>Composite</td><td>☐</td> <td>Supplier</td><td>☐</td> <td></td><td></td> </tr> </table>		Loss tube	☐	Water Jet	☐	Engineering	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐	Composite	☐	Supplier	☐																				
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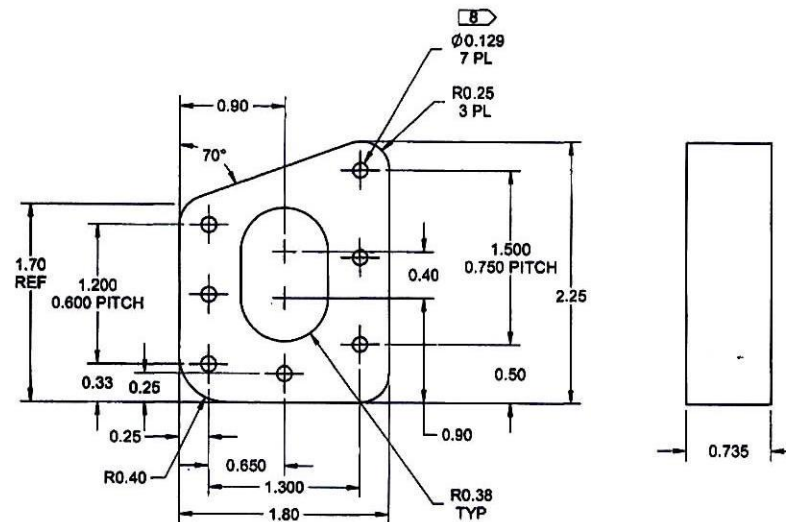
DART AEROSPACE LTD		Work Order: 170908
Description: Spacer		Part Number: D552-3
Inspection Dwg: 5552	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0,735	+/- 0,020	0,741	1		VDC-2	
1,80	+/- 0,030	1,803	1			
2,25	+/- 0,030	2,252	1			
1,70	+/- 0,030	1,706	1			
0,129	+0,005 - 0,001	,129	✓		P.G.	
,25	± 0,030	,248	✓		Vern	
1,300	± 0,010	1,301	✓		HG	
,33	± 0,030	,325	✓		HG	
,600 pitch	± 0,010	,599	✓		Vern	
1,200	± 0,010	1,199	✓		Vern	
0,50	± 0,030	,506	✓		HG	
,750 pitch	± 0,010	,749	✓		Vern	
1,500	± 0,010	1,498	✓		Vern	
,650	± 0,010	,651	✓		HG	
,25	± 0,030	,248	✓		Vern.	
,735	± 0,010	,740	✓		mic.	

Measured by: SC/amp	Audited by: DAS 20 9-89	Preliminary Approval:
Date: 18/01/20	Date: 18-02-21	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	



D5552-3 SPACER

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4118)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4180)
OR ASTM B211 OR ASTM B221
REF DART SPEC M8061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.20 lbs
- 8) MASK HOLES PRIOR TO POWDER COAT
- 9) UNDEFINED FEATURES CONTROLLED BY CAD FILE D5552-3 REV. A.SLDPRT

RELEASED
2018-01-08

APPROVED

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	EUGENE, OR	
CHECKED	WK	DRAWING NO.	REV. A
MFG. APPR.	RQ	D5552	SHEET 2 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	SPACER	NTS
DATE	17.07.24	COPYRIGHT © 2017 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	